Work Order ID	55872
THULK CIUCI ID	JJU / E



Page 1

February 3, 2010 1:35:44 PM

Item ID:

D4006-1

2/03/10

QC:

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Angle

Start Qty: 2.00

Req'd Qty: 2.00

Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 2/10/10

Process Plan:

Date: 0-2-0

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours**

Draw Number Draw Rev.

Plan Accept Code Qty

Reject Qtŷ

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr D4006 /

100

Waterjet

FLOW CNC Waterjet

500. PGOG

Memo

1-Cut as per Dwg

Dwg Rev: ORF
Prog Rev: Lim

0.00

0.00

2-Deburr if necessary

B 10-2-11

110

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B10-3-11

Quality Control

PRELIMINARY ISSUE

Dart Aeros	pace Ltd
------------	----------

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHAN	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: \	es N	lo DQ .	A:	_ Date: _	
	Res	solution:	Disposition	:	_ QA: N/	C Clos	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC	Initial	Corrective Action Sect Action Description	ion B	gn &		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Secti	ion C	Chief Eng	QC Inspector
									,	
							-			
	1		1						Í	

February 3, 2010 1:35:44 PM

Item ID:

D4006-1

Accept



Setup Start



Stop

Revision ID:

Item Name: Angle

Required Date: 2/10/10

2/03/10 **Start Date:**

Start Qty: 2.00

Req'd Qty: 2.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date: ___

Run Start

Stop



Date: _____

SPC (Y/N):

Draw Number

Draw Rev.

Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Work Center ID 120

Sequence ID/

QC Quality Control Operation **Description**

QC8- Inspect parts - second check

Cloonis@ minul tol.) &

Memo

Set Up/ **Run Hours**

0.00

Sidnly

130

Bend as per dwg

0.00

So colo2/12

Brake NC

Brake NC

140

De Singet he went step 5 > Sidal 16

150

HandFinish

Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

Memo

0.00 bl 10-02-17

W/O:			W	ORK ORDER CHANG	ES			·· ·		,
DATE	STEP	PRO	OCEDURE CHA	NGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	NCR:	NCR: Yes No DQA: Date: _					
	Re	esolution:	Dispositio	n:	_ QA: N	/C Clo	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)		-		
DATE	STEP	Description of NC	1	Corrective Action Section		·: 0	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	on C	Chief Eng	QC Inspector
										i
		Α,								
								1		
										4
			-							

Work Order ID 55872

February 3, 2010 1:35:44 PM



Page 3

Item ID:

D4006-1

Accept

Setup Start

Stop

Start



Revision ID:

Item Name: Angle

Required Date: 2/10/10

2/03/10 **Start Date:**

Start Qty: 2.00

Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Plan

Code

Stop

Reject

Qty

Run



Sequence ID/ Work Center ID

160

QC

Quality Control

Operation **Description**

QGS- Inspect part completeness to step on W/O

QC: Date: SPC (Y/N):

QC3

Memo

Set Up/ **Run Hours**

0.00

F1)50)01 / 10(02(17

Draw

Number

Draw

Rev.

Date: ____

Accept

Qty

Reject

Insp. Number Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

POSITIVE RECALL

RELEASED _____ DATE ____

R10-2-19

Dart Aerospace Ltd

	•									
W/O:			WO	RK ORDER CHAN	GES					€ * .
DATE	STEP	PR	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	gory:	NCR: Y	es No	DQA	:	_ Date: _	
	Reso	olution:	Disposition	1:	QA: N/C	Close	ed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	IANCE (N	CR)				
DATE	STEP	Description of NC			ction B		Verification		Approval	Approval
	O L	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n & ite	Sectio		Chief Eng	QC Inspector
										·
	1				1	l				

Picklist Print

February 3, 2010 1:35:48 PM

Work Order ID: 55872

Parent Item:

D4006-1

Parent Item Name: Angle

Comments:

IPP rev A 09.12.18 new issie Prelim EC verified by:DD



Start Date: 2/03/10

Required Date: 2/10/10

Page 1

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Locatio	 Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No		sf	214.3696				
									1310-2-11	

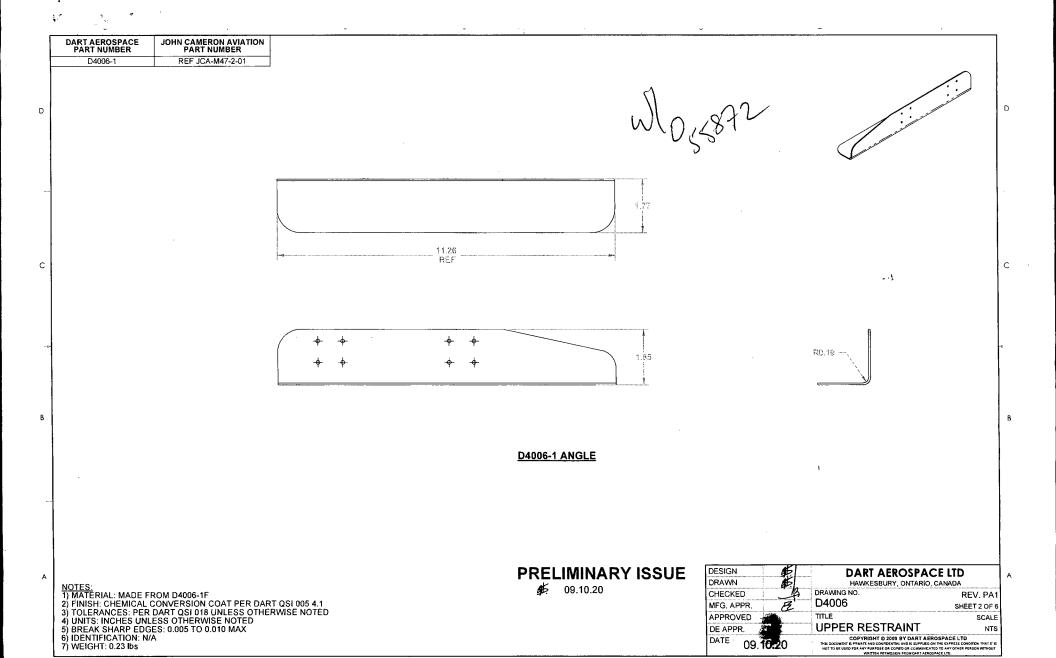
2024-T3 .063 sheet

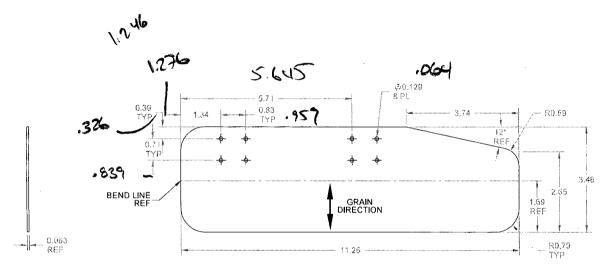
Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
MAT	214.3696242		
102942	1.5		102947
105916	1.09		
109463	0.00947368		
110980	5.4854		
111787	12.2847505		
113866	96		-
113867	96		
19059	2		



Dart Aerospace Ltd

	•								× .			
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
]							
-					j							
Part No	:	PAR #:	Fault Cate	egory:	_ NCF	R: Yes 1	lo DQ	4 :	_ Date: _			
	Res	solution:							Date:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)						
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
		. , .										
						****.						





D4006-1F FLAT PATTERN

NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.23 lbs

PRELIMINARY ISSUE

₡ 09.10.20

DESIGN	DART AEROSPA	DART AEROSPACE LTD				
DRAWN #	HAWKESBURY, ONTARI					
CHECKED	A DRAWING NO.	REV. PA1				
MFG, APPR.	D4006	SHEET 3 OF 6				
APPROVED	TITLE	SCALE				
DE APPR.	UPPER RESTRAINT	NTS				
DATE 09.10.20	COPYRIGHT © 2003 BY DART A THIS GOCULENT IS PRANTE AND COMPIDENTIAL AND IS SUPPLY NOT TO BE USED FOR ANY PURPOSE DIS COPED DIS CONUM. WRITTEN FERMISSIM FROM DART A	ED ON THE EXPRESS CONDITION THAT IT IS ICATED TO ANY OTHER PERSON WITHOUT				

DART AEROSPACE LTD	Work Order:	55872
DANT ALNOST AGE STO		
Description: ANGLE	Part Number:	D4006-1
Description. ANACI		
Inspection Dwg: D4000-1 Rev: pretan Pal		Page 1 of 1
inspection Dwg: 1) 1000 Nev. (1500)		

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

		11100711011			T	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	1.005-601	1130	P			
,39	4 030	,375	*			
۱۲٫	14 .00	וה	8	<u> </u>		
1,34	14 030	1.313	12	<u> </u>		
,83	7 .00	1887	7	ļ		
5,71	7 00	5 690	8			
11.26	7 30	11.240	0			,
3.46	7 30	3,468	8			
3,74	4 .00	3,747	×			
.063	12 ,010	10/4	7	 		
			<u> </u>		Ĭ,	·
			 		`	
			,	 		
			1			
						94
		*				
l						_

Maggyrod by:	m	Audited by:	Prototype Approval:	N/A
Measured by:	``~	Date: Volgo	Date:	N/A
Date:	10-9-11	Date. 100214		

_				Revised by	Approved
1	Rev	Date	Change	KJ/JLM	
ſ	Α		New Issue	7,070,00	· · ·

